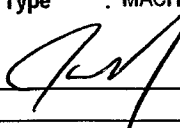


Date: Thursday, 05/06/2008 1:09:40 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 39725	
Estimate Number : 12322	
P.O. Number :	Part Number : D3492041
This Issue : 05/06/2008 S.O. No. :	Drawing Number : D3492 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 39676	Material :
Written By : 	Due Date : 12/06/2008 Qty: 100 Um: Each
Checked & Approved By :	
Comment : est rev A 06.03.03 New Issue EC	
Est Rev:B 06-08-28 As per Rev B JLM	
Est Rev:C 07-12-06 Rev C dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6R0625	6061-T6 Round Bar .625"
-----	--------------	-------------------------



(100)



Comment: Qty.: 0.0656 f(s)/Unit Total : 6.5625 f(s)
 6061-T6 Round Bar .625"
 (M6061T6R0625)
 Batch: MK7513

J.F. /mmf 08/06/07

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA633 & Dwg D3492
 Dwg Rev: B
 Folio Rev: 2AA

(100)

J.F. /mmf 08/06/07

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



(100)



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. /mmf 08/06/07

(100)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.F. /mmf 08/06/07

(100)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if neccesary
 2-Tumbler

08/06/09 100 Jm
 08/06/12 100 counted

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 39725

Part Number: D3492041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(100)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/06/13

7.0

POWDER COATING

POWDER COATING



M107925



(100x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:15 p.m.
320 °F
2:45 p.m.

M-L 08/06/16

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-06-16

(X100)

9.0

NAS1611010

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-010 O-RING

(or MS28775-010)

M106533 (40x)
M100539 (60x)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

1- Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube

A/R 55-O'Ring Lube Batch:

M101223

08-06-17

(X100)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/06/18 (X100)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP-1

YJ

08-16-17

(X100)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 39725

Part Number: D3492041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/19 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08-06-18

DART AEROSPACE LTD		Work Order:	39725
Description: Plug		Part Number:	D3492-1
Inspection Dwg: D3492	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

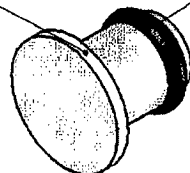
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	.060"	✓			
0.060	+/-0.005	.059"	✓			
Ø0.394	+/-0.010	Ø.395"	✓			
Ø0.625	+/-0.010	Ø.622"	✓			
0.090	+0.000/-0.002	.089"	✓			
0.500	+/-0.010	.499"	✓			
0.055	+0.000/-0.002	.055"	✓			
.050" x 20°	± .010"	.040"	✓			

Measured by: J.F.	Audited by: RD	Prototype Approval:	N/A
Date: 08/06/06	Date: 08/06/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.02	New Issue P/O D3492-041	KJ/JLM	
B	06.10.16	Ø0.625 was Ø0.500	KJ/JLM	
C	07.11.23	Tolerances revised	KJ/EC/DD	

D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



w/ 39725

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING



NOTES:

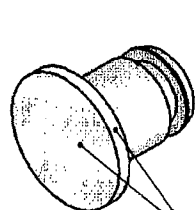
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

-041
-051
06.06.05
UNDER REVIEW
01.04.21
DIM 0.04 IN D3492-13
REVISION (WHICH SMALLER?)

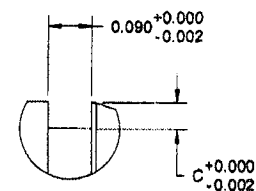
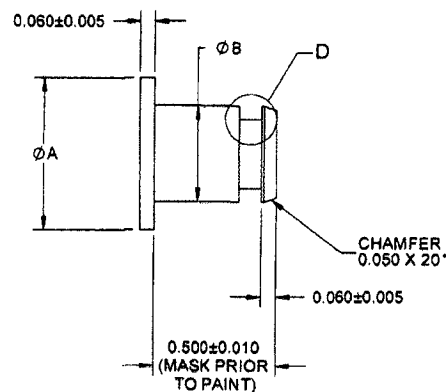
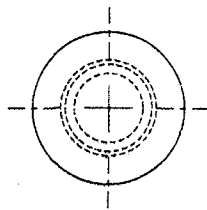
RELEASED
07.10.05

C	ADD -049/-051/-053. CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047. UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3492	REV. C
TITLE PLUG	SHEET 1 OF 2
SCALE 2:1	
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POWDER COAT THESE
FACES ONLY PER NOTE 2



DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-8	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.860	0.684	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3492 REV. C
MFG. APPR.		SHEET 2 OF 2
APPROVED		TITLE PLUG SCALE 4:1
DE APPR.		
DATE	07.10.05	

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-041
RD 08-06-05
UNDER REVIEW
01.04.11/BA
DIM ØB IN D3492-13
REV. 11 (TWICE SMALLER)

RELEASED
07.11.16

52168 9/25